

Wednesday, 5/16/2007 8:13:38 AM
Kim Johnston

Process Sheet

SPLIT-1

23

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE
 Job Number : 32379 Part Number : D29331
 Estimate Number : 10833 Drawing Number : D2933 REV C
 Job Number : N/A Project Number : N/A
 Job Issue : 5/16/2007 S.O. No. : N/A Drawing Revision : C
 Job Rev. : NC Material : N/A
 Job Issue : N/A Type : MACHINED PARTS Due Date : 5/8/2007 Qty: 16 Unit
 Job Run : 32022
 Written By :
 Checked & Approved By :
 Comment : Est: B 00.05.26 New DWG rev (mpp 2069) EC
 Est Rev C As per Rev C 07-03-19 JLM

Original Product

Seq. #	Machine Or Operation:	Description:
1.0	D5101001	7075-T7351 2X6X6.25
Comment: Qty: 1,0000 Each(s)/Unit Total: 16,0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Out Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No. B33356		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No.1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No.2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No.3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Debur		
3.0	MILLING CONV	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet		
4.0	Q01	INSPECT ALL DIM TO DIM SHEET
Comment: INSPECT ALL DIM TO DIM SHEET		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 32379

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J-F-07/06/27 (4)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-f 07/06/27 (2x)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

710: 4058 C/L 07/06/27 (2)

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C-7/7/04 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/04 (2)

Job Completion



12 07-07-04

7.1) QC 14

2 07-07-03 2

DART AEROSPACE LTD		Work Order: 32379
Description: 206 Saddle, Inboard, Left side		Part Number: D2933-1
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.126	0.127	0.126	0.127		
B	0.100	0.140		0.127	0.126	0.124	0.127		
C	0.100	0.140		0.126	0.126	0.130	0.125		
D	0.210	0.230		0.224	0.225	0.224	0.224		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.494	2.501	2.501	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		0.126	0.126	0.126	0.125		
O	0.540	0.560		0.550	0.551	0.545	0.545		
P	0.490	0.510		0.502	0.496	0.498	0.496		
Q	3.715	3.725		3.717	3.715	3.715	3.719		
R	2.470	2.510		2.494	2.484	2.484	2.484		
S	0.240	0.270		0.252	0.254	0.254	0.254		
T	0.100	0.180		0.137	0.137	0.137	0.137		
U	1.625	1.635		1.631	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.136	1.136	1.136	1.136		
Y	1.565	1.585	DT8695 A/B	1.574	1.575	1.575	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>ML/SA</i>	Audited by: <i>J.F.</i>
Date: 07.06.26	Date: 07/06/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>